

# Work Order ID 83466

**\*83466\***

Page 1

April-18-12 2:38:46 PM

Item ID: D2654-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Web

Start Date: 18/04/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/18 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2654

F

100

0.00

**\*100\***

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-5 to length as per Dwg D2654  
2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654  
3-Using the uni-bit, open holes to finish size as per Dwg D2654  
4-Deburr holes and ends

2 JS 11-05-22

110

QC5- Inspect part completeness to step on W/O

0.00

**\*110\***

QC

Memo

0.00

Quality Control

2 JS BE 12/05/22

120

Chemical Conversion Coat per QSI005 4.1

0.00

**\*120\***

HandFinish

Memo

0.00

Hand Finishing

JS 12-05-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Revision ID:

Item Name: Web

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Start Date: 18/04/2012 Start Qty: 2.00

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Cust Item ID:

Required Date: 02/05/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00							
<b>*130*</b>						<b>x2</b>	<b>0</b>	<b>BE 12/05/23</b>	
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <b>LG</b>	0.00							
<b>*140*</b>								<b>12-05-23</b>	
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
<b>*150*</b>								<b>12/5/3001</b>	
QC	Memo	0.00							
Quality Control								<b>MS 12/05/22</b>	

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 83466

\*83466\*

Parent Item: D2654-3

\*D2654-3\*

Parent Item Name: Web

Start Date: 18/04/2012

Required Date: 02/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108		Manufactured	No			100	Each	152.0000	1	2			
*D2600-5-108*									**				
Extrusion 'I Beam' thin													

2 11-05-22

Location

Loc Qty

Loc Code

LG

152

47814

20

13909

132

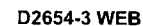
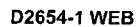
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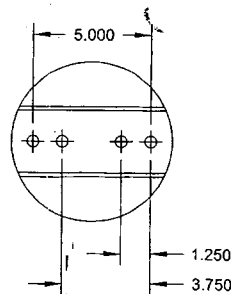
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NO. 83466MLJ

12/04/18



### DETAIL A

C2-1  
C3-1  
C6-1  
C8-1  
D3-2  
D6-2  
B3-2  
B6-2

RELEASED  
2011-09-12

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER PART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs  
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2		SC	11.05.05
E	CHANGE LENGTHS, REFORMAT		CP	04.05.26
D	GHW HOLES CHANGED TO Ø0.63		CP	98.01.15
C	CHANGED HOLE PATTERN		CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438		CP	97.06.26
A	NEW ISSUE		CP	97.03.25
REV.		DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE USA, INC</b>		
DRAWN	SC	PORT HADLOCK, WA		
CHECKED	<i>JP</i>	DRAWING NO.	REV. 1	
MFG. APPR.	<i>BE</i>	D2654	SHEET 1 OF 1	
APPROVED	<i>JP</i>	TITLE	SCALE	
DE APPR.	<i>JP</i>	WEB	NT	
DATE	11.05.05			
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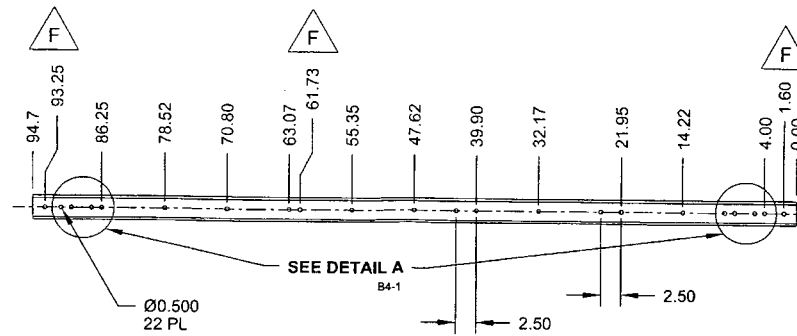
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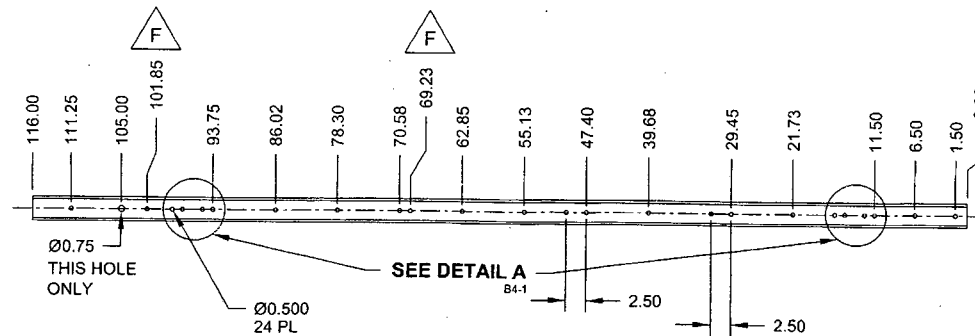
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**D2654-5 WEB**



**D2654-7 WEB**

83466

RELEASED  
2011-09-12

DESIGN	CP	<b>DART AEROSPACE USA, INC</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>g</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>E</i>	D2654	SHEET 2 OF 2
APPROVED	<i>g</i>	TITLE	SCALE
DE APPR.	<i>g</i>	WEB	NTS
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